WELDING PROCEDURE SPECIFICATION

APPLICABILITY
ASME ☐ AWS ☐
OTHER

WPS - _____

REVISION NO. _____ DATE _____

WELDING PROCESS(ES) _____ & _____

SUPPORTING PQR(S): _____

This WPS shall be used in conjunction with the GWS Sections and criteria for joint Detail, cleaning, repairs, NDE, inspection, etc.

WELD JOINT: Type: _____ Class: _____

Sketch No _____ Preparation: _____

Backing: _____ Backing Gas Flow Rate: _____ to _____

Back Grind Root: ☐ Yes ☐ No *Optional backing without gas

FILLER METALS SFA Class: _____ & _____ Class: _____ & _____

A No.: _____ F No.: _____ & _____ Size: _____ _____ _____

INSERT **WELD METAL THICKNESS RANGE**

FLUX TYPE: _____ SIZE: _____ AWS _____ to _____

Additional Notes _____ ASME _____ to _____

BASE MATERIALS P No. _____ Gr. No. _____ to P No.: _____ Gr. No. _____

Spec. _____ Grade: _____ to Spec. _____ Grade _____

Pipe Diameter Range: Groove: _____

Thickness Range: Groove _____ AWS: _____ Thru _____

ASME _____ Thru _____

QUALIFIED POSITIONS: _____ PWHT: Time at ºF _____ Hr(s)

_____ Temp. Range ºF _____

PREHEAT Min. Temp. ºF _____ GAS: Shield _____ or _____

INTERPASS: Max Temp ºF _____ Composition: _____ % _____ % _____ %

PH MAINT: ºF _____ Flow Rate CHF _____ to _____

PREPARED BY: _____ DATE: _____

APPROVED BY: _____ DATE: _____

WELDING CHARACTERISTICS WPS NO. _____

Current: _____ and _____ Transfer Mode: _____ Fuel Gas: _____

Ranges: Amps: _____ TO _____ Pulsing Cycle: _____ to _____

Volts _____ TO _____ Background Current _____

Tungsten Type: _____ Flame: ___ Braze Temp: _____ ºF to _____ ºF

WELDING TECHNIQUE: For cleaning, grinding, and inspection criteria refer to the General Welding Standard.

GMAW: Gun Angle º _____ to _____

Stringer (S) or Weave (W) Bead _____ Forehand (F) or Backhand (B) for GMA _____

Oscillation: ___ Single Pass (S) or Multi Pass (M) _____ Travel Speed/IPM: _____

PROCEDURE QUALIFIED FOR: Charpy "V" _____ NDTT _____ DT _____

MAXIMUM K/J HEAT INPUT: _____

WELD* LAYER	PROCESS	FILLER METALS	SIZE	AMP RANGE	VOLT RANGE	TRAVEL IPM	NOZZLE ANGLE º	OTHER
1								
2								
3								
4								
5								
6								
7								
8								
Balance								

*Weld layers are representative only – actual number of passes and layer sequence may vary due to variations in joint design, thickness, and fit-up.